

## CLAIMS

What is claimed is:

- 1           1.     A method for manufacturing a piston comprising a disk-shaped  
2     base body having opposed sides, through-channels between the sides, and a support  
3     raised above one of the sides for supporting a valve disk, each said through-channel  
4     being surrounded by a support body raised above one side for supporting a valve disk,  
5     and a recess recessed below the opposite side, said method comprising:  
6                 receiving said base body between a pair of die tool halves, and  
7                 pressing a forming tool into one of the body to form said support by  
8     material flow.
- 1           2.     A method as in claim 1 further comprising removing material within  
2     said support to provide a through-opening.
- 1           3.     A method as in claim 2 wherein the diameter of the forming tool is  
2     smaller than the diameter of the through-opening.\
- 1           4.     A method as in claim 1 comprising pressing a pair of forming tools  
2     into respective opposed sides of said base body synchronously to form a pair of said  
3     opposed supports on respective opposed sides of said base body by material flow.
- 1           5.     A method as in claim 1 wherein said tool die halves comprise said  
2     forming tool, said method comprising:

3                    providing a stamping blank for said base body, said stamping blank having  
4   a greater thickness than said base body after pressing said forming die therein; and  
5                    forming said support by upsetting said tool die halves so that the forming  
6   tool is pressed into said one of said sides.

1                    6.     A method as in claim 5 wherein the differential volume between the  
2   stamping blank and the base body after pressing said forming die therein flows into said  
3   support.